

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011384**Date Inspected:** 11-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Ying Xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**BAY 10**

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% and Randomly Visual Testing of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6027 (UT) report for this date. The member is identified as North Tower skin E internal splice plate. The weld designations reviewed are as follows.

NSD1-SPSA4-22-1~2A/B

NDT Notification No: 005041

**BAY 11**

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% and randomly Visual Testing of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Fit lug & Diaphragm from 131m to 143m Diaphragm area. The weld designations reviewed are as follows.

131M-ESTL4-2H/L-90,81,82,79,80,10,11,77,78,134,135

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## WELDING INSPECTION REPORT

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135M-ESTL4-2I/L-76,77,80,81,20,22,79,80,192

139M-ESTL4-2J/L- 6,7,10,11,35,36,8,9

143M-ESTL4-2K/L -76,77,21,22,13,12,136

NDT Notification No: 005045

This QA Inspector observed the following work in progress:

BAY 10

### Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 057258 perform Shielded Metal Arc Welding (SMAW) on Tower strut. Joint identified as ND1-STSA3-1-99M-1-11A/B, ZPMC QC Identified as Chen Ying Xin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G(2F)Repair.

### Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040365 perform Shielded Metal Arc Welding (SMAW) on Beam. Joint identified as ND1-BPSA5-1-1-5A/B, ZPMC CWI Identified as Du Zhiquan. Using Critical welding report no-CWR-T-CWR532.The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F) Repair.

### Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 057258 perform Shielded Metal Arc Welding (SMAW) on Beam. Joint identified as ND1-BPSA5-2-1-5A/B, ZPMC CWI Identified as Du Zhiquan, Using Welding Repair report no-WRR-T-WR2957. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F) Repair.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this projec

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod phone: 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Shailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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